

Date: Monday, 2/27/2006 4:17:40 PM
User: Kim Johnston

Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET		
Job Number:	25964	Part Number	: D32051		
Estimate Number:	11139	Drawing Number	: D3205 REV A		
P.O. Number:	N/A	Project Number	: N/A		
This Issue:	2/27/2006	S.O. No.:	: N/A		
Prsht Rev.:	NC	Drawing Revision	: A		
First Issue:	N/A	Material	: N/A		
Previous Run:	N/A	Due Date	: 3/20/2006 Qty: 10 Um: Each		
Written By:	<u>SPC Document Below</u>				
Checked & Approved By:	<u>06.02.28</u>				
Comment:	Est A 04.06.09 New issue KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
		Comment: Qty.: 0.3828 f(s)/Unit Total : 3.8283 f(s) 7075-T73 Bar 2.5 x 3.25" Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4) (M7075T73B2.500x03.25) Identify for D3205-1 Batch: <u>M17046</u> <i>W 060313</i>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1 Deburr and Tumble
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JL 06.03.05 10</i>
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>Ep 060305 10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/05	3	- 3 parts scrap - 2 dimension - 250 is under tolerance, <i>Machined cracked</i> . - 1 part lifted while machining	<i>AB</i> <i>AB/03/05</i>	- scrap & replace	J.L 06/03/05	<i>J</i> 06/03/05	<i>AB</i> <i>AB/03/05</i>	<i>AB/03/06</i>

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:17:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25964

Part Number: D32051

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

03:03:06

10

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

a.m 06-03-09 10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MM 06 03 09 10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 414

16/3/13 10

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q 06/03/14

Job Completion



W 06/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25964
Description: Pedal Bracket	Part Number:	D3205-1
Inspection Dwg: D3205	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	M.S	Prototype Approval:	N/A
Date:	06/03/04	Date:	06/03/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

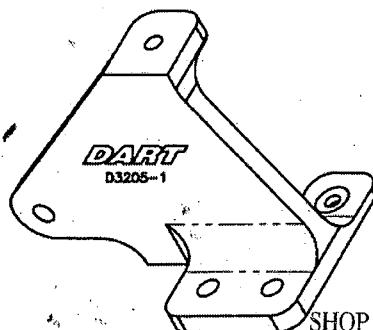
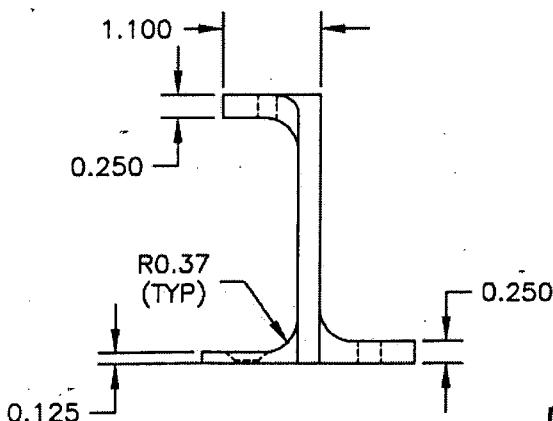
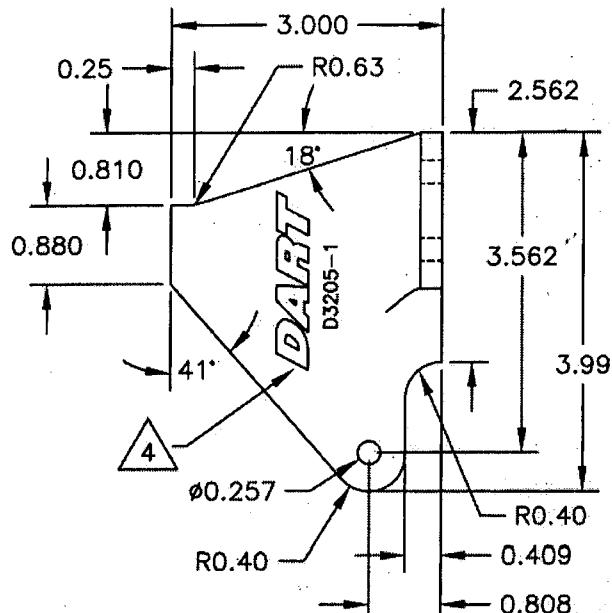
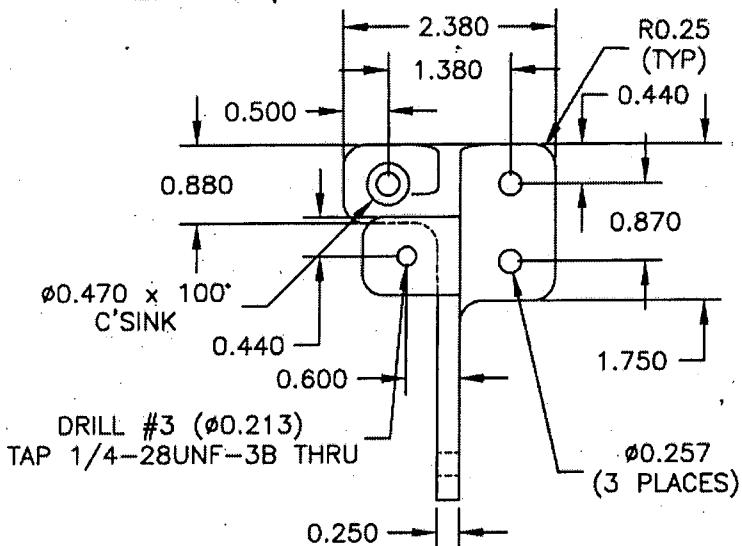


A circular stamp with the words "COPY ISSUED" printed in a curved, bold, sans-serif font, with a small "C" at the top.

DESIGN 	DRAWN BY 	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO.	SHEET 1 OF	
DATE 04.01.27		TITLE BRACKET	SCALE 1:2	
A	04.01.27	NEW ISSUE		

RELEASED
09-09-05 #

04.04.05



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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER /

25964

NO. 25964

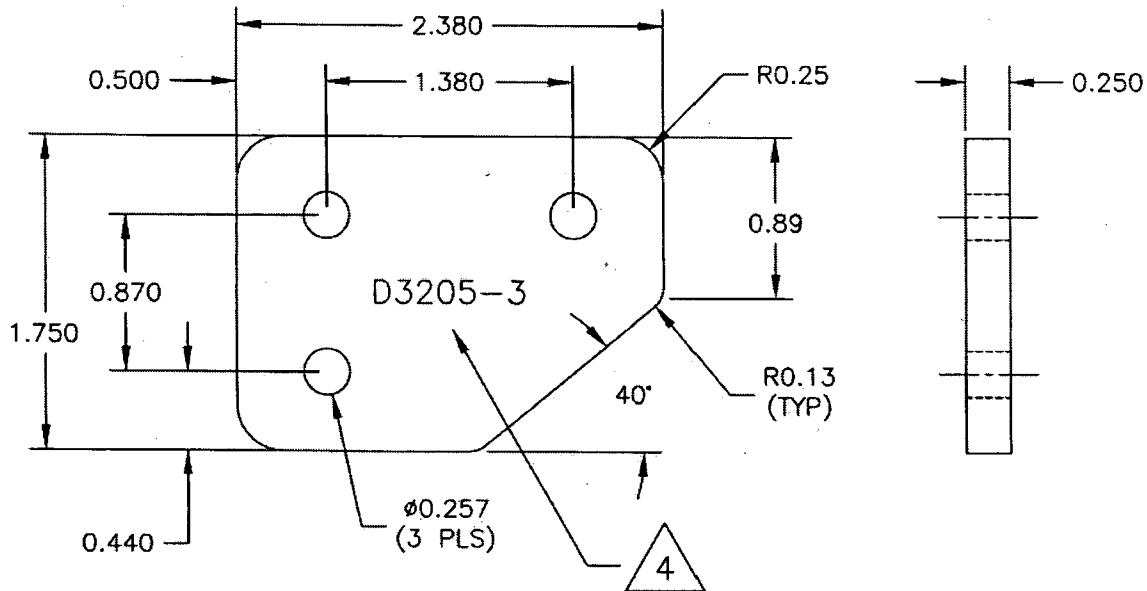
NO. 25964
005 4.3

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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D3205-3 BACK PLATE

NOTES:

BREAK ALL SHARP EDGES 0.005 TO 0.015

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3

ENgrave DART P/N AS SHOWN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE INCHES

WORK ORDER NO. 25964
ENGINEERING DRAWING
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RELEASED
04.04.05

DART

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03

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
W	W	D3205
04.01.27		BRACKET

REV. A
SHEET 2 OF 2
SCALE 1:1